

Date: Thursday, 2/14/2008 2:21:03 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 37452B		
Estimate Number	: 10354		
P.O. Number	:	Part Number	: D2322
This Issue	: 2/14/2008 S.O. No. :	Drawing Number	: D2322 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 36710B	Material	:
Written By	:	Due Date	: 2/25/2008 Qty: 12 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 05-11-07 JLM		
	: Est Rev:B Now on Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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3



Comment: Qty.: 0.2132 sf(s)/Unit Total : 2.5578 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2322
 Batch: 106272 B 8-2-20

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2322
 Dwg Rev: C
 Prog Rev: C

B 8-2-20

(14)

2-Deburr if necessary

B 8-2-20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-2-20



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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10602-20

(14)



Comment: SECOND CHECK

counted

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Form as per Dwg D2322

SB 02/02/27

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/03/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP SPACER

Job Number: 37452B

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



08-02-27 (14X)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(14X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. L.

08/02/27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-27

(14X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/3/3

SD

(14X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/04

Job Completion



mi 2008/3/04 (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QA COPY ISSUED

DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. C
CHECKED	KE	APPROVED	MM	DRAWING NO.	D2322	SHEET 1 OF 1
DATE	98.09.29			TITLE	STEP SPACER	
A	94.10.14			NEW ISSUE		
C	98.09.29			4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001		

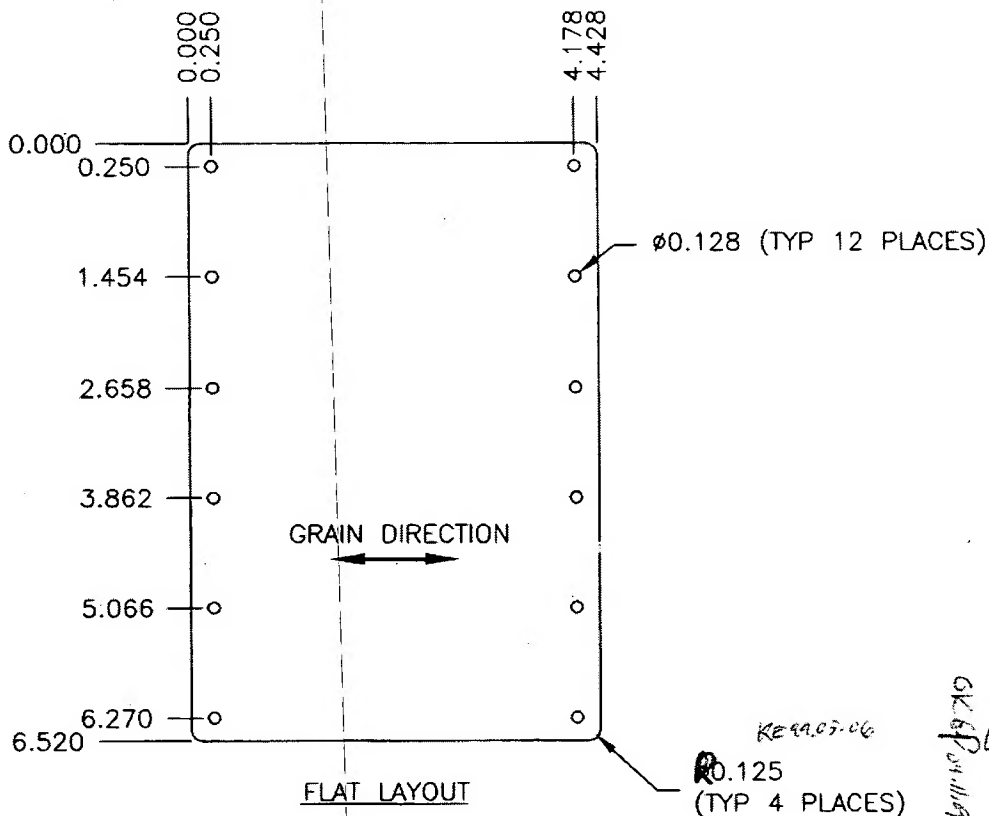
RELEASED
18.10.08 DS

UNDER REVIEW

01.03.15

DESIGN OF, BUT CHECK WITH
ITS BEFORE MANUFACTURE

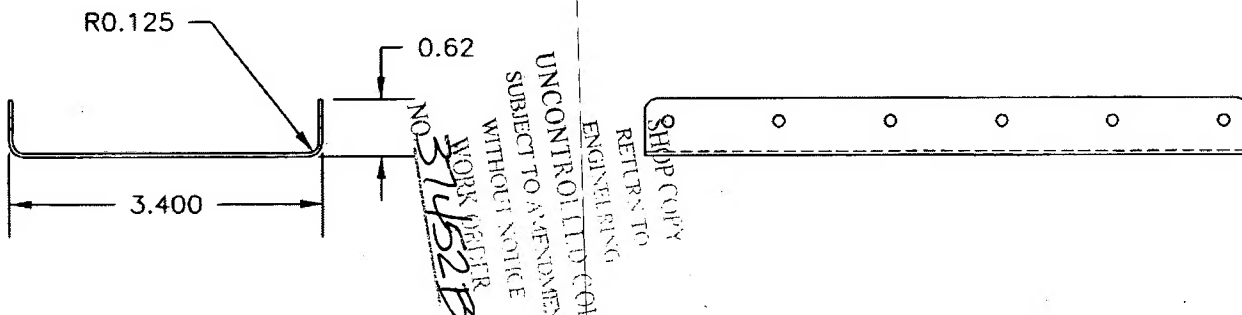
OK 6/24/1109



KE 99.05-06

0.125
(TYP 4 PLACES)

FLAT LAYOUT



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED